

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020343**Date Inspected:** 01-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. An Qing Xing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

SEGMENT # 9W:

Flux Cored Arc Welding (FCAW) of weld joint OBW9C-007(9DW-9EW,SP-SP), Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Mr. Shi Li. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233T.

FCAW Welding of weld joint OBW9A-005 (9CW-9DW,EP-EP), Welder is identified as 046706. ZPMC Quality Control (QC) is identified as Mr.Zhang Xiao Ming. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-F.

FCAW Welding of weld joint SP771-001-25~36 (9CW-9DW,T-Rib), Welder is identified as 040704. ZPMC Quality Control (QC) is identified as Mr. Shi Li. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW9-002(DP-DP,9AW-9BW).And Critical Welding Repair Report (CWR) B-CWR-1698,Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Shi Li. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G-FCM-REPAIR-1.

SMAW welding of weld joint CA061-006/CA065-002(DP-EP,9CW-9DW). Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Shi Li. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint SP134-001-044~054(9CW-9DW). Welder is identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Shi Li. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

CB # 11:

SMAW welding of weld joint DP202-011-017,018(CB#11,Hold Back Area). Welder is identified as 069896/067829. ZPMC Quality Control (QC) is identified as Mr. Xu Jin Zong. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Visual Inspection (VT):

This QA Inspector performed VT of the area previously Inspected and accepted by ZPMC Quality Control personnel. The member is identified as CB#12, Panel Points 081~082.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
